44

DART AEROSPACE LTD.	Work Order:	21519
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty	
1	DC	Issue Traveller	W	2/200	10	
		Dwg not required	PY	04.09.17	12	
2	MV	Make from D6101-007 billet for D2571				
		Ensure that grain is along 7.75" length	5	1 .		
		Batch No: 137098 \$	8	64/11/22	7	
3	MV	Make from D6101-005 billet for D2572	1			
		Ensure that grain is along 5.00" length			<u></u>	
		Batch No: 73 7.07 8 3	(e)	04/11/27	12	
4	MV	Fixturing W/O No. N/A	da	11		
		Fixturing Inspection last completed of 11/27 by	Op	64/11/27	12	
5	M∨	Program Batch No. BZISIS	En	1. 1		
		Double check by: M	40	oylulez	17	
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	En		_	
	8437	Dimension Sheets	141	a/11/30	12	
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached	Ep	111-	_	
	h 4) /	Dimension Sheets	14)	odlill30	17.	
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached	5	41.15	. ¬	ĺ
9	MV	Dimension Sheets	147	04/4/30	12	
9	IVI V	Machine keyway as per dwg D2571 & D2572	8	1.10	\	
10	MV	Debugg and serviced by a chicken and the	7	04/4/38	12	_
10	IVIV	Deburr and remove all machining marks	5	04/4/30	12	Pi
11	MV	Tumble for 20 minutes to remove shar adges # 04.00.21	19	04/11/70	٠ ـــ	
11	IVIV	it if oy we if	8	04/12/04	12	
12	QC1	Inspect all dimensions to dimension sheets	+-	CILIVICA		
12	Q O1	inspect all differsions to differsion sheets	Si	04/12/01	15	
13	QC7	Second inspection		04112101		
,,	Q 0.	- Coodina mopodaom	1	04.12.01	12	
14	FP	Acid etch and alodine as per QSI 005 4.1	12			
• • •		Tiona diam and another do por dor doo 4.1	m	J41203	12	
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	111	,,,,,,		
		Toward Court ng/1 Close Willia (1.5.5.1) por Qui court.	INI	04 12 06	11.	
16	QC3	Inspect Powder Coat	1 " "	- 1		
		mapour chack dou.	17	04/12/06	12	
17	ST	Identify and Stock.	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	= 377 \(\int \)		
		· · · · · · · · · · · · · · · · · · ·	CX	04112106	10	
18	AC			11.5.100		
		Cost/Part 115 99 93.64	Sur	01-12.07	12	
19	DC	Cost / Part // 5 99 93.6 9 Close W/O //3.68 93.69	10			
		Inspection Level 21	XX	64.12.09	12	

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	/
Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ PF	_X/

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